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TITLE: PULSE OUTPUT CONTROL METHOD, AND CONSUMABLE
ELECTRODE TYPE PULSE ARC **WELDING** EQUIPMENT

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ABSTRACT:

PROBLEM TO BE SOLVED: To suppress the generation of the **spatter** by repeatedly supplying the peak current and the base current in a pulse manner between a **welding** wire and a **welding** base material, setting the pulse period of the current using at least one of a **welding** output electrode or the set **welding voltage** to regularly generate the short circuit for each pulse.

SOLUTION: The short circuit to be generated in every pulse when the **welding voltage** is dropped is regularly generated, and the generation of the **spatter** is suppressed by setting the pulse period so as not to change the

average of the pulse frequency when the welding voltage is dropped. In setting the pulse period, a limiter set part to set an upper limit value and a lower limit value of the pulse period according to at least one of the wire feed, the wire diameter or the wire material is provided in a pulse output set part 10a to stabilize the welding. A pulse frequency set part 11 to operate the pulse period can be set by the wire feed or the like. The spatter is suppressed by predicting the detachment of the droplet to complete the peak period.

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